

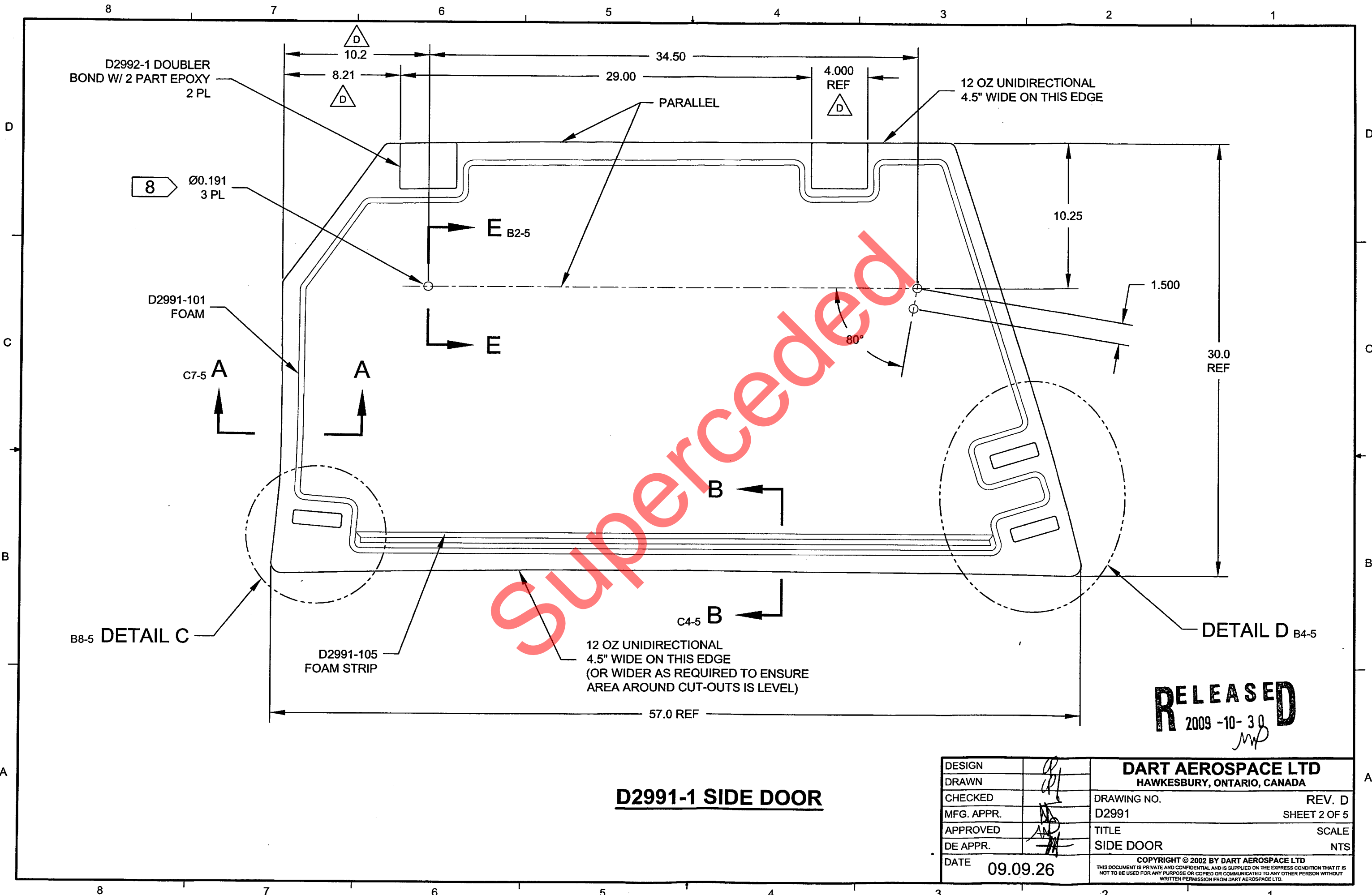
**D2991-1/-2/-3 SIDE DOOR**

**NOTES**

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR  
USE MOLD DT8627 FOR D2991-2 SIDE DOOR  
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR  
DT8629 FOR D2991-2 SIDE DOOR  
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005  
9 OZ SATIN  
9 OZ SATIN  
FOAM  
FOAM STRIP  
9 OZ SATIN  
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)  
9 OZ SATIN  
RESIN (35-45% BY WEIGHT)  
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

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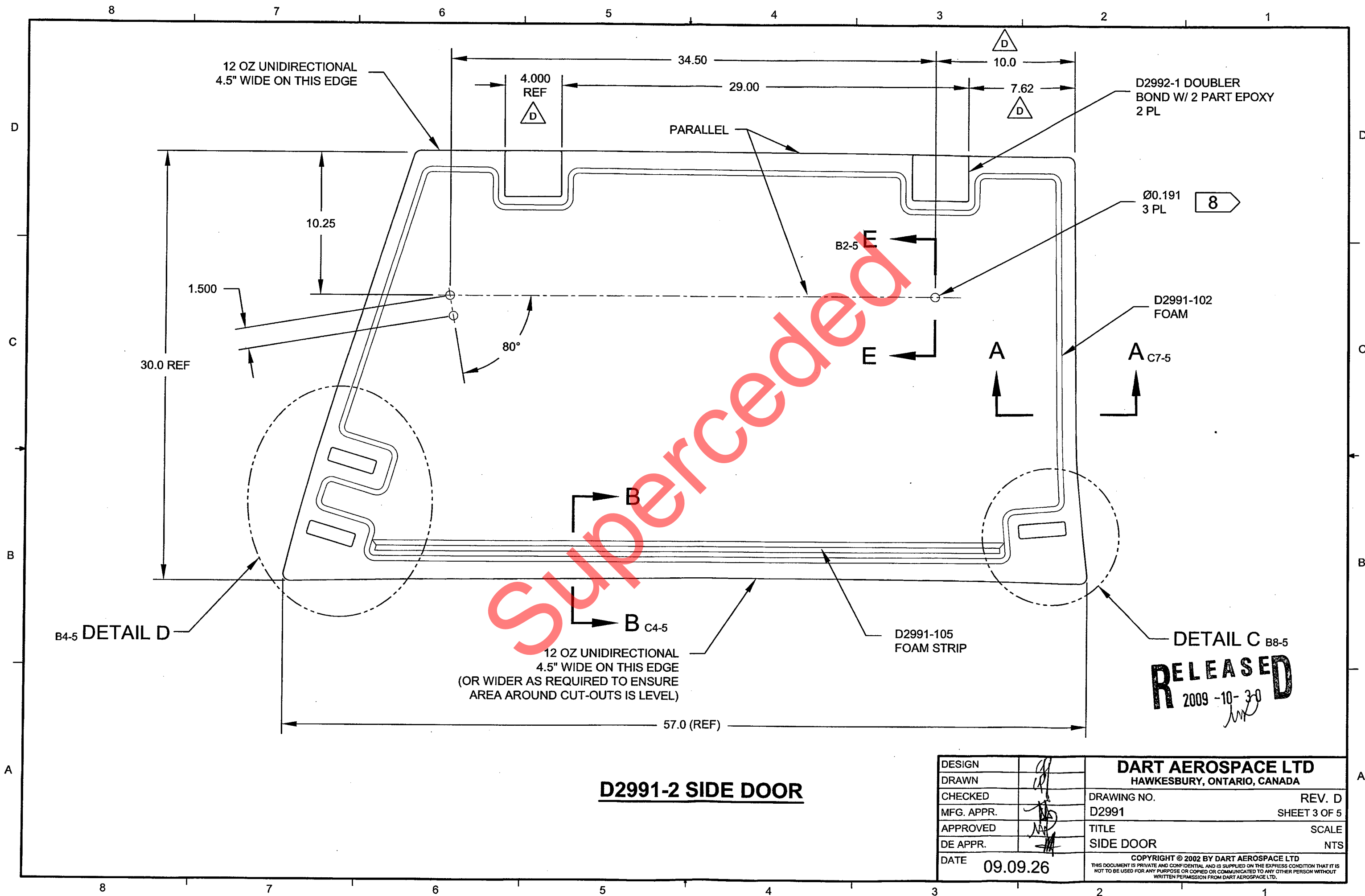
D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP		
MFG. APPR.	CP		
APPROVED	CP		
DE APPR.	CP	DRAWING NO. D2991	
DATE	09.09.26	REV. D SHEET 1 OF 5	
		TITLE SIDE DOOR	
		SCALE NTS	
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**D2991-1 SIDE DOOR**

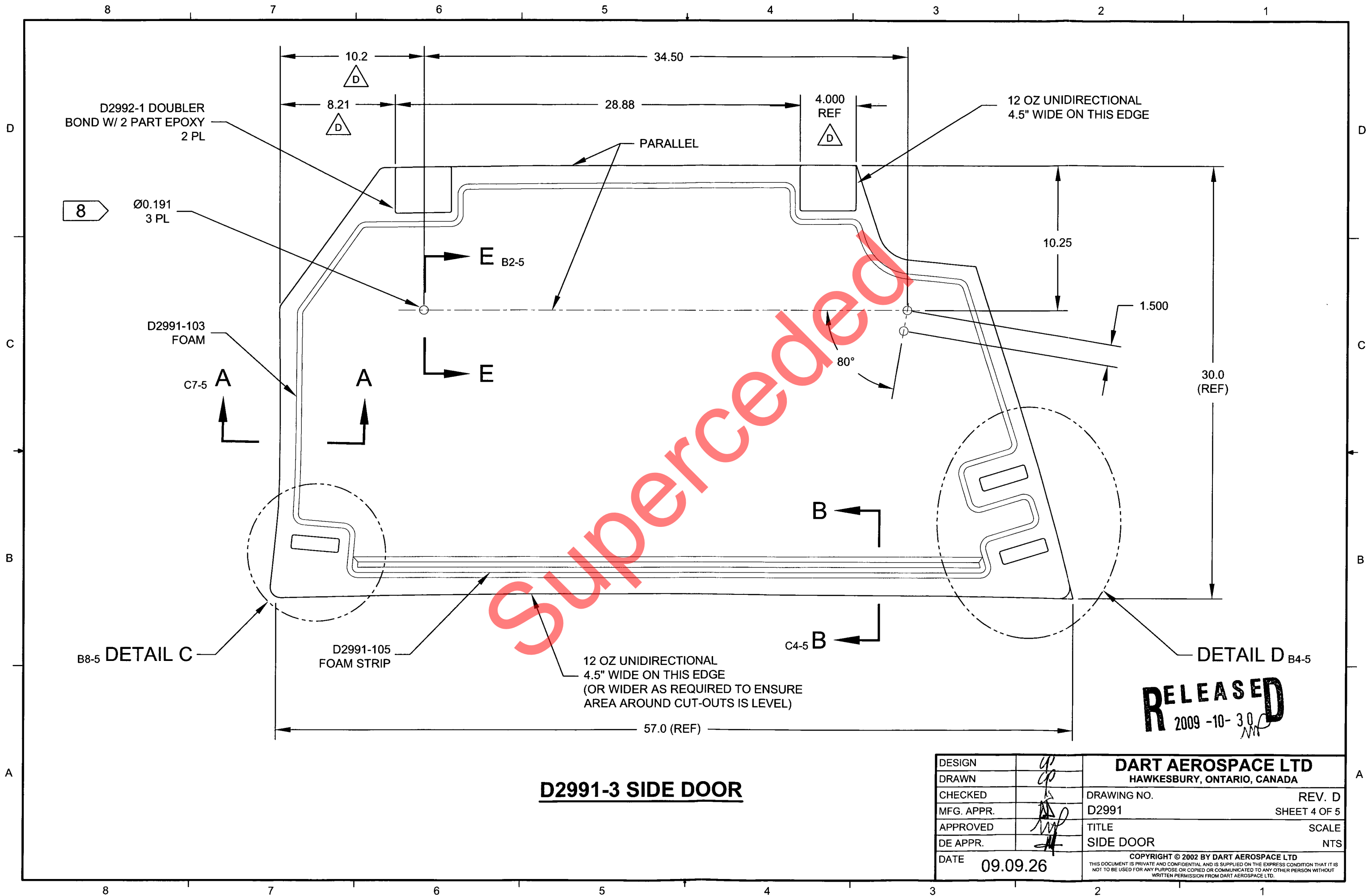
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CHECKED	<i>AS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AS</i>	D2991	SHEET 2 OF 5
APPROVED	<i>AN</i>	TITLE	SCALE
DE APPR.	<i>AN</i>	SIDE DOOR	NTS
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### D2991-2 SIDE DOOR

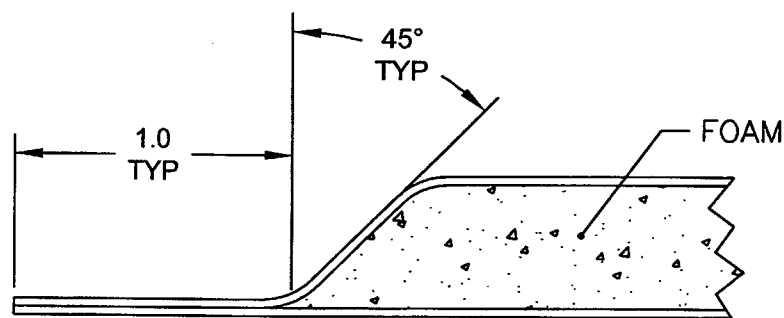
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MFG. APPR.		D2991	SHEET 3 OF 5
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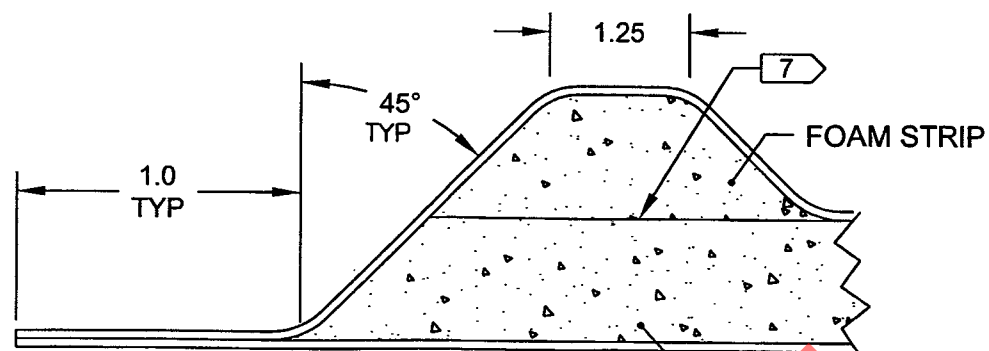
**D2991-3 SIDE DOOR**

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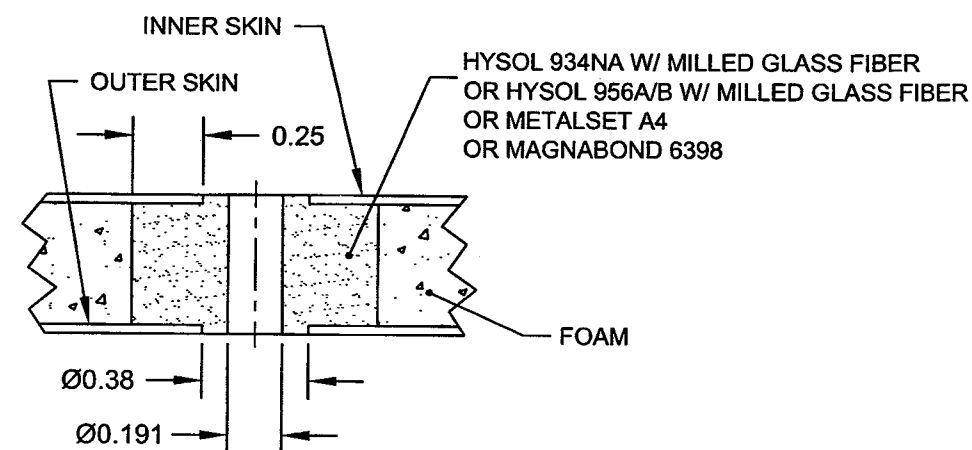
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MFG. APPR.	MP	D2991	SHEET 4 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SIDE DOOR	NTS
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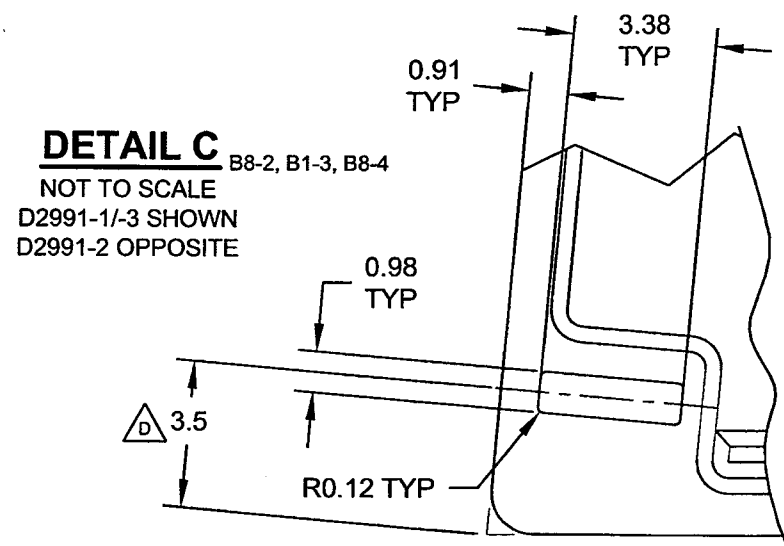
**SECTION A-A** C7-2, C2-3, C7-4  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



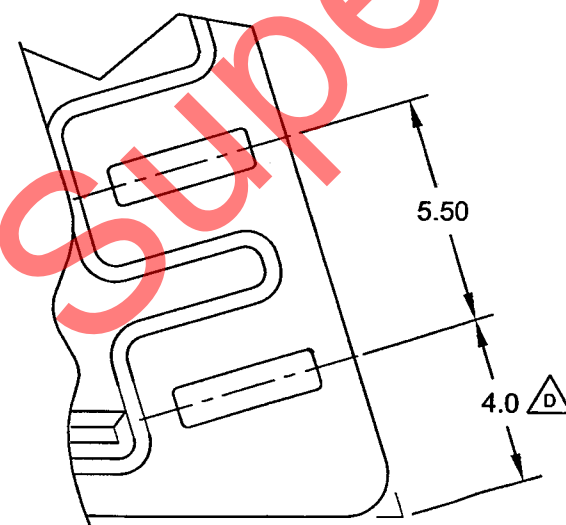
**SECTION B-B** B4-2, B5-3, B4-4  
ONE EDGE ONLY  
NOT TO SCALE, VIEW ROTATED  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



**SECTION E-E** D6-2, D3-3, C6-4  
TYPICAL Ø0.191  
HOLE DETAIL  
NOT TO SCALE



**DETAIL C** B8-2, B1-3, B8-4  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



**DETAIL D** B1-2, B8-3, B1-4  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE

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DE APPR.		SIDE DOOR	NTS
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